

Date: Thursday, 5/10/2007 2:09:08 PM
 User: Kim Johnston

Process Sheet

S.P.I.P.

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L FLOAT STEP
 Job Number : 32254 -2
 Estimate Number : 10850
 P.O. Number : N/A Part Number : D206628024
 This Issue : 5/10/2007 S.O. No. : N/A Drawing Number : N/A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : N/A
 Previous Run : 26753 Material : N/A
 Written By : Due Date : 5/30/2007 Qty: 1/4 Um: Each
 Checked & Approved By : H. J. O'Sullivan
 Comment : Est Rev:D As Per Ecn 766 06-01-06 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels as per PPP D206-628-024 CHG 002

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 32254A FLOAT STEP ASSEMBLY LH (206/407)



Comment: Sub-Component FLOAT STEP ASSEMBLY LH (206/407)

D2842-042 B 32254A

4.0 D27317 Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2731-7 Mounting Lug

B29339

B30995

5.0 D28441 Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2844-1 Arm

B29285

7/6/21 Ser

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FLOAT STEP

Job Number: 32254

Part Number: D206628024

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D28443

Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2844-3

Arm

B14087 ✓

7.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2660 f(s)/Unit Total : 5.0639 f(s)

Pick :

Qty Part #

Description

Batch

2 D2856-400 6.9" Abrasion Strip

B32020 ✓

8.0

D3394043

LUG ASS'Y



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 D3394-043 LUG ASS,Y

B30998 ✓

B30998 ✓

9.0

AN3C4A

BOLT



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 AN3C4A

Bolt

M104214 ✓

M104214 ✓

10.0

AN4C12A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C12A

Bolt

M103691 ✓

M103691 ✓

11.0

AN4C13A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C13A

Bolt

M19600 ✓

7/6/25 SA
7/6/21 SA

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FLOAT STEP

Job Number: 32254

Part Number: D206628024

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN4C15A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C15A

Bolt

M100447

M102959 (4)

13.0

AN960C10

WASHER



Comment: Qty.: 3.0000 EACH(s)/Unit Total : 12.0000 EACH(s)

Pick:

Qty Part Number

Description

Batch

+1 3 AN960C10

WASHER

M101064

M101064

14.0

AN960JD416L

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 96.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

+1 24 AN960JD416L Washer

M103962

M104214

15.0

NAS1515H4L

Inventory



Comment: Qty.: 24.0000 Each(s)/Unit Total : 96.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

+1 24 NAS1515H4L Washer

M103691

M103691

16.0

MS210434

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

+1 12 MS21043-4 Nut (or MS21042-4)

M103715

28
M104603

17.0

NAS1515H3

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

+1 3 NAS1515H3 Washer

M100993

M100993
7/6/21 SG
7/6/25

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FLOAT STEP

Job Number: 32254

Part Number: D206628024

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

07/06/28 (1) SR 07/06/28 (1)

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-024

Location: _____

PPP Rev: _____

R

07/06/28 (1)

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(1) 07/06/29

Job Completion



12 07-06-28

206628024

Dart Aerospace Ltd.

Date:
User:Thursday, 5/10/2007 2:09:26 PM
Kim Johnston

Process Sheet

shp 28/06

SPVt 20621

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 32254A -1-2
 Estimate Number : 11775
 P.O. Number : N/A
 This Issue : 5/10/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : LARGE FAB ASSY
 Previous Run : 31239A
 Written By :
 Checked & Approved By : 2007.05.10
 Comment : Est Rev:D As Per Ecn 766 06-01-06 JLM

Drawing Name : FLOAT STEP ASSEMBLY RH (206/407)
 Part Number : D2842042
 Drawing Number : D2842 REV B
 Project Number : N/A
 Drawing Revision : B
 Material : N/A
 Due Date : 5/30/2007 Qty: 4 Um: Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D2622120C

Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	B31984

Check Material for any Dents or Defects

K. a. m 07.06.19

2.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2842-1 using D2622 extrusion as per Dwg D2842

K. a. m 07.06.19

2-Drill D2842-1 using Jig DT8271 as per Dwg D2842

K. a. m 07.06.19

3-Deburr and bevel ends for welding

K. a. m 07.06.19

3.0

D2734

206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

206 Step Endplate

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	B30883

K. a. m 07.06.19

4.0

D34591

plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

plate

Batch: B30909 = 4 B32292

K. a. m 07.06.19

Date:
User:

Thursday, 5/10/2007 2:09:26 PM
Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 32254A

Part Number: D2842042

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

D34593

plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

plate

Batch: 831238

PE 07-06-19

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld one end cap and (2) lugs using jig DT followed by DT as per Dwg D2842

A/R AL Rod Batch: M102756
M104305

2-Grind end cap weld flush

PE 07-06-20

PE 07-06-20

FF 07-06-20

7.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

QC5 07-06-20 (4)

QC9/D 07-06-20 (4)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Er 07-06-21 (x3)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Er 07-06-21 (3)

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Remove alodine prior to welding.

Weld end cap as per Dwg D2842.

A/R AL Rod Batch: M102756

2-Grind end cap weld flush.

a.m 07-06-21

PE 07-06-21

File: Thursday, 5/10/2007 2:09:26 PM
User: Kim Johnston

Process Sheet

RH

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY (206/407)

Job Number: 32254A

Part Number: D2842042

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

06/06/21 (3)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5/2 07-06-21

(3)

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Touch up Alodine end cap and Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

M 104144 BR/M-h

(3)

07-06-25

14.0

NAS1329C3KB130

insert



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Insert

Pick:

Qty Part Number

Description

Batch

3

NAS1329C3KB130

Insert

M102974

15.0

MS27039C107

screw



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3

MS27039C1-07

Screw

M19522

16.0

NAS1515H3L

WASHER



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3

NAS1515H3L

WASHER

M1104603

17.0

AN960C10L

washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3

AN960C10L

WASHER

M102473

07-06-25 (3)

Date: Thursday, 5/10/2007 2:09:26 PM
User: Kim Johnston

Process Sheet

RH

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY (206/407)

Job Number: 32254A

Part Number: D2842042

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: FINISHING 1

1-Install inserts as per Dwg D2842

2-Wing Walk as per Dwg D2842 and QSI 005 4.1

Batch: M104733

Handwritten: 40 07-06-25 (3)

Handwritten: 40 07-06-25 (3)

19.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

Handwritten: 07/6/28 (1)

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Handwritten: PPA 332 254 07/6/28

21.0

QC21

FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE

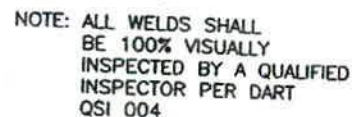
Handwritten: 07/06/29

Job Completion



Handwritten: 07-06-28

DESIGN	DRAWN BY		DART AEROSPACE USA, INC.	
KE	PH		PORT HADLOCK, WA	
CHECKED		APPROVED		DRAWING NO. D2842
DATE	05.09.23		TITLE	206L/407 FLOAT STEP ASSEMBLY
A	98.10.13		SCALE	NTS
B	05.09.23		RE-DESIGN, ADD D3459-1/-3	



QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2B42-041	LH STEP ASSEMBLY
	X	D2B42-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AES510KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER

Technical drawing showing a cross-section of a structure. The drawing includes a vertical line on the left, a horizontal line at the top, and a diagonal line forming a 45.0° angle with the horizontal. A dimension of 1.000 is indicated for the vertical height. The drawing is labeled "SHOP CORE RETURN TO OFFERING" and "D2734 END PLATE".

1) MAKE FROM EXTRUSION D2622
2) WELD PER DART QSI 004
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
4) ALL DIMENSIONS ARE IN INCHES
5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

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